



Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-151

Job Sheet 195404



Part No: D206-642-151

Job Qty: 1 pcs

Part Name: Replacement Skidtube, Low Gear with Run-on Landing Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3804 REV A(DEO), IIN-D206-642 REV Q SHEETS 13,26 IPP REV:A 10.12.08 PER IIN REV:N DD
VERF:EC IPP REV:B 11.09.16 PER IIN REV:O DD VERF:EC IPP Rev:C 12.11.22 now swage per ecn12-679
DD verf:JLM IPP Rev:D 14.04.24 ECN14-520 DD verf:JLM IPP Rev:E 16.04.04 as per CHG004(ecn16-553)
DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	6/7/19		0.00	1.82	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	6/7/19		0.00	0.00	QC 5 - 10		MAY 27 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS 24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	QC 9	1 pcs	6/7/19		0.00	0.00	QC 5 - 9		MAY 27 2019
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 9 - 10		
							QC 9 - 18	DAS 24	
							QC 9 - 24	9-89	
							QC 9 - 43		
							QC 9 - 50		



Container No: S133928

Part: D206-642-151

Job No: 195404

Serial No/Batch: S183928

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, 16/5/21, STC SH98-

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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140 Handfinish - 1-1 Chemical- B4B	1 pcs	6/7/19	0.00 0.33	QC 9 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	A MAY 28 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	6/7/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	M66
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	

160 Skidtubes - 2 - B4B	1 pcs	6/7/19	0.00 2.00	QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	6/7/19	0.00 1.82	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
190 QC 5	1 pcs	6/7/19	0.00 0.00	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
200 Skidtubes - 4 - B4B	1 pcs	6/7/19	0.00 2.84	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
215 QC 9	1 pcs	6/7/19	0.00 0.00	Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 9 - 10	
				QC 9 - 18	DAS 24 9-89
230 QC 5	1 pcs	6/7/19	0.00 0.00	QC 9 - 24	JUN 0 6 2019
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS 24 9-89
				QC 5 - 3	JUN 0 6 2019
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
240 Handfinish - 4-1-Assembly-B4B	1	6/7/19	0.00 0.78	Handfinish - 4 - 1 - B4B		
pcs				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		✶ JUN 10 2019
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
250 Powdercoat - 1 White GI(A)-B4B	1	6/7/19	0.00 0.25	Powdercoat - 1 - B4B		
M175459.	pcs			Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		BE 19-6-26
START: 10:15 O.T. 3:00 FINISH: 10:45				Powdercoat - 4 - B4B		
260 QC 3	1	6/7/19	0.00 0.00	QC 3 - 10		
pcs				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		BE 19-06-26
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
270 Handfinish - 4-2-Assembly-B4B	1	6/7/19	0.00 1.00	Handfinish - 4 - 1 - B4B		
pcs				Handfinish - 4 - 10 - B4B		BE 19-06-26
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 -		
				</		

				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 Handfinish - 3-1- WingWalk-B4B	1 pcs	6/7/19	0.00 0.60	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	BEB 19-06-26
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
290 QC 3	1 pcs	6/7/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	JUL 26 2019 9-59
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
300 QC 5	1 pcs	6/7/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUL 26 2019 9-59
310 Packaging 3-1 - Stock - B4B	1 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
315 DC - 1 - B4B	1	6/7/19	0.00 0.00	DC - 1 - B4B	AUG 02 2019
	pcs			DC - 2 - B4B	
320 QC 21 - FG	1	6/7/19	0.00 0.00	QC 21 - FG - 21	AUG 02 2019
	pcs			QC 21 - FG - 70	

Part Op 110 - Skid tubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld
 Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

120 - QC5- Inspect part completeness to step on W/O

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Skid tubes -1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B(without cutting fluid) 3-Deburr and blow out all chips from inside the tube

180 - Skid tubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

190 - QC5- Inspect part completeness to step on W/O

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

215 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish4 Assemble as per dwg

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg - - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

315 - Document Control - Photocopy bluefile & type labels per PPP D206-642-151 CHG004
 320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	S165744
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	S166098
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes - 3 - B4B	S084750 4
D2654-1	Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	S171694
D3286-1	Doubler	2 pcs (2 ea)	180-Skidtubes - 3 - B4B	F1687141
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B	S156881
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B	S140137
D4720-1	Spacer	18 pcs (18 ea)	200-Skidtubes - 4 - B4B	S154510
D2651-1	Plug	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	S167951
D2651-3	O-Ring	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	S027453
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	F141543
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	FM137622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	FM1378F6-0
AN3-37A	Bolt	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	S166888
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	S160607
D3805-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	S145465
D3805-045	Run-on Landing Wearplate Aft	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	S187203
D3873-1	Bushing	14 pcs (14 ea)	280-Handfinish - 3-1- WingWalk-B4B	S175778
MS21042L3	Nut	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	S157462-1
MS27039-1-08	Screw	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	S180295
MS27039-4-06	Screw	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	S166974-1
NAS1149D0332J	Washer	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	S178378
NAS1149D0363J	Washer	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	S176547
NAS1149D0463J	Washer	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	S055952

M.D. 010625 / M.D. 010626

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	6	0
	D2647	1	45	0
180-Skidtubes - 3 - B4B	CR3212-4-04	52	747	0
	D2654-1	1	5	0
	D3286-1	2	34	0
200-Skidtubes - 4 - B4B	D2649	1	70	0
	D3286-3	2	24	0
	D4720-1	18	222	0
270-Handfinish - 4-2-Assembly-B4B	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2651-1	6	95	0
	D2651-3	6	322	0
	D2680-041	1	12	0
280-Handfinish - 3-1- WingWalk-B4B	AN3-37A	7	71	0
	D2646	1	39	0
	D3805-041	1	3	0
	D3805-045	1	0	0
	D3873-1	14	92	0
	MS21042L3	7	2,464	0
	MS27039-1-08	2	475	0
	MS27039-4-06	1	95	0
	NAS1149D0332J	2	3,738	0
	NAS1149D0363J	7	1,582	0
	NAS1149D0463J	1	3,551	0

Part Specifications

Specifications could not be found.

Plex 5/21/19 3:27 PM Dart.lajeunesse.marie

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1	1	D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3266-1	DOUBLER
15	2	2	D3266-3	STUD
21	2	2	AN860JD10L	WASHER
22	1	1	AN860JD416	WASHER
23	2	2	COR2646S3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-06	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.3.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-281 ADHESIVE PER DART QSI 016
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE)

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WITHOUT NOTICE
WORK ORDER

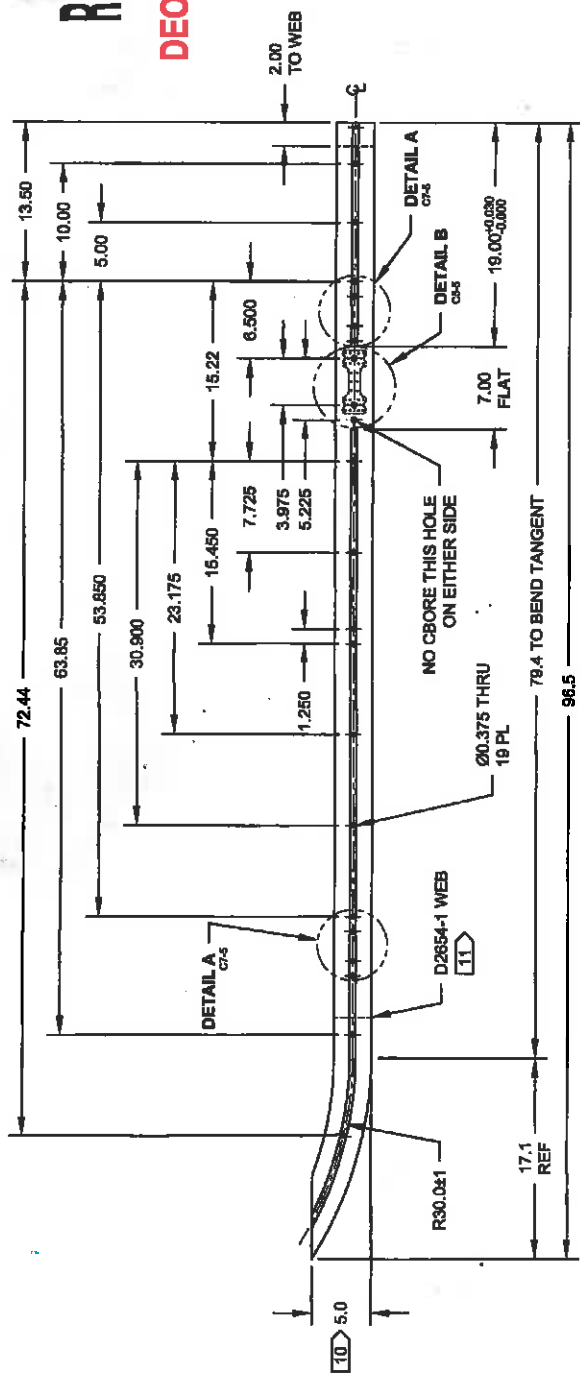
195704M5
19-05-22

DEO ATTACHED
RELEASED
R 10.03.83
PC E2 N 01-5%
19-05-22

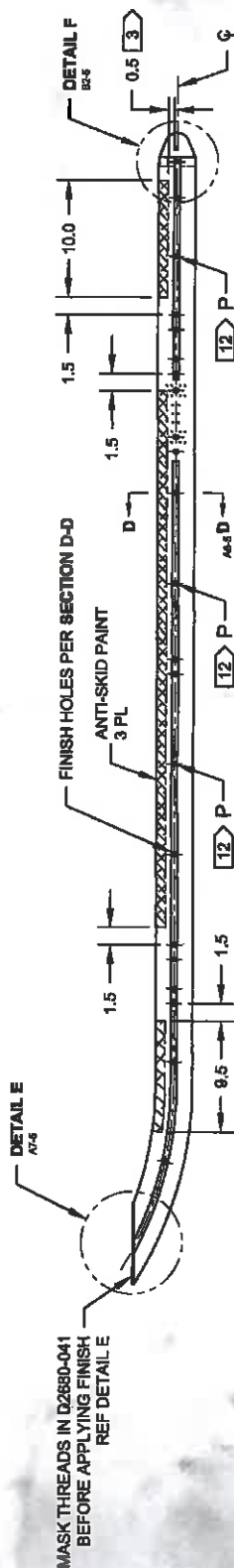
A	REV.	NEW ISSUE	DESCRIPTION	MB	BY	DATE
	DESIGN					
	DRAWN					
	CHECKED					
	MFG. APPR.					
	APPROVED					
	DE APPR.					
	DATE	08.07.07				
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3804 REV. A SHEET 1 OF 5 TITLE SKIDTUBE ASSEMBLY, 206A/B SCALE NTS COPYRIGHT © 2003 BY DART AEROSPACE USA, INC ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.						

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09-15-83

DEO ATTACHED



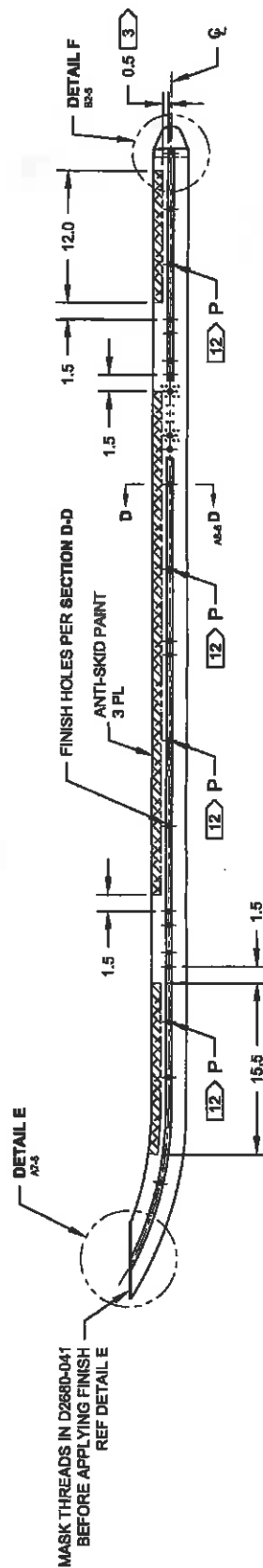
D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	67	DART AEROSPACE USA, INC
DRAWN	67	PORT HADLOCK, WA
CHECKED	67	REV. A
MFG. APPR.	67	D3804
APPROVED	67	SHEET 2 OF 5
DE APPR.	67	SCALE
DATE	08.07.07	NTS
SKIDTUBE ASSEMBLY, 208A/B		
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DEO ATTACHED

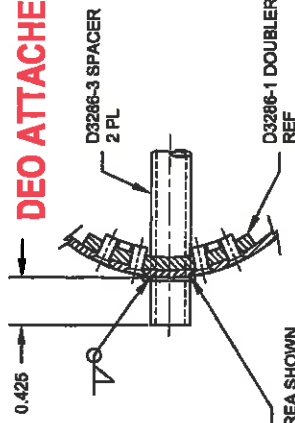


D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	<i>4</i>	DART AEROSPACE USA, INC		
DRAWN	<i>1</i>	PORT HADLOCK, WA		
CHECKED	<i>1</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>1</i>	D3804	SHEET 3 OF 6	
APPROVED	<i>1</i>	TITLE	SCALE	
DE APPR.	<i>1</i>	SKIDTUBE ASSEMBLY, 208AVB NTS		
DATE	08.07.07	CONFIRMED & SIGNED BY DART AEROSPACE USA, INC THIS DOCUMENT IS NON-PROTECTABLE AND IS EXEMPT FROM THE PATENT AND COPYRIGHT LAWS THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC		

RELEASED
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DEO ATTACHED

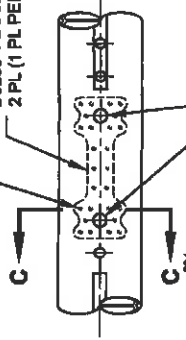


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE

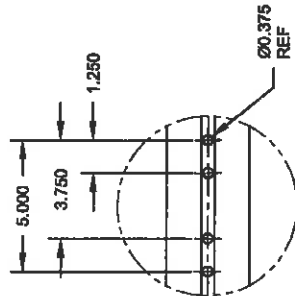
Ø0.128 THRU WALL
CSINK Ø0.229 X 100°
INSTALL CR3212-4-04 RIVET
52 PL (28 PL PER DOUBLER)

D3286-1 DOUBLER
2 PL (1 PL PER SIDE)

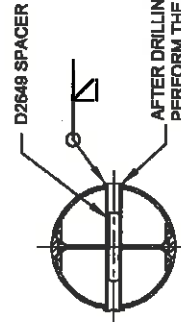


ENLARGE TO Ø0.500 IN D3286-1
ENLARGE TO Ø0.625 IN TUBE
4 PL (2 PL PER SIDE)

DETAIL B
SCALE NONE



DETAIL A
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2849 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	1	DART AEROSPACE USA, INC
DRAWN	1	PORT HADLOCK, WA
CHECKED	1	DRAWING NO.
MFG. APPR.	1	REV. A
APPROVED	1	SHEET 4 OF 5
DE APPR.	1	SCALE
DATE	08.07.07	NTS
		SKIDTUBE ASSEMBLY, 208A/B
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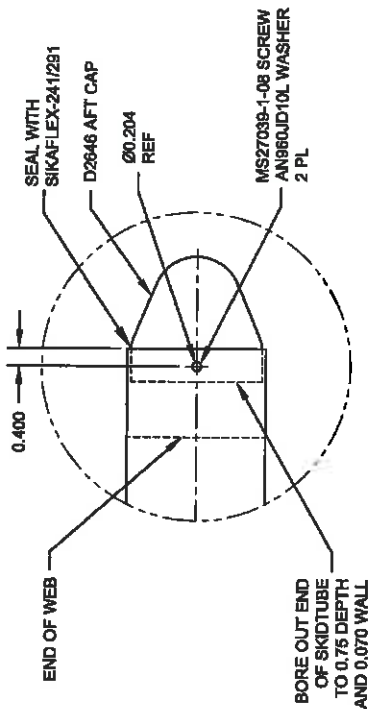
RELEASED

DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CCR264SS3-3
RIVET
2 PL

VIEW G-G
SCALE NONE



DETAIL F
SCALE NONE

- D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS REQD)
 4. WELD D2647 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

MS27039-4-08 SCREW
AN860JD418 WASHER
D2680-041
NUT PLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE

DESIGN	41	DART AEROSPACE USA, INC
DRAWN	41	PORT HADLOCK, WA
CHECKED	41	DRAWING NO.
MFG. APPR.	41	D3604
APPROVED	41	TITLE
DE APPR.	41	SKIDTUBE ASSEMBLY, 206A/B
DATE	08.07.07	SCALE
		NTS

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DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 12.10.12	CHECKED A.P.	DATE 12.10.22	MFG. APPR.	APPROVED	DATE 12.10.22	DE APPR.	
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	

PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

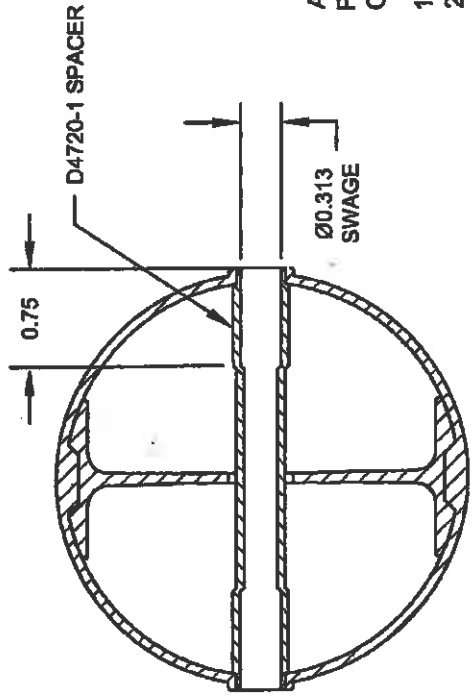
IS:

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

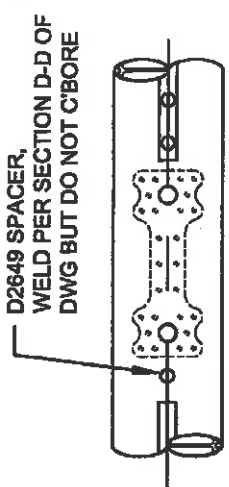
WAS:

19	20	D2649	CROSS BOLT SPACER
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ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG. C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



SECTION H-H
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASE
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____		Job: _____		Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)	
		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____		Sequence #: _____		QTY Affected: _____							
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											

Root Cause		FAULT CATEGORY									
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐		
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐		
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐		
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐		
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐		
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐		
Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		☐		
Human Factors	☐	Other/Details:									